

Date: Tuesday, 7/18/2006 2:33:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 5-MAN SHOULDER HARNESS KIT
Job Number	: 27935		
Estimate Number	: 10409		
P.O. Number	: <u>N/A</u>	Part Number	: D412702033
This Issue	: 7/18/2006 S.O. No. : <u>N/A</u>	Drawing Number	: DSI 9312 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 27235	Material	: <u>N/A</u>
Written By	: <u>SEA COMMENT BELOW</u>	Due Date	: 7/25/2006
Checked & Approved By	: <u>06.07.19</u>	Qty:	3 Um: Each
Comment	: Est Rev:A 05.11.03 New issue KJ/EC Est Rev:B 06-04-03 Remove Comments,Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-702-033CHG001

u 260720

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

✓

3.0	D31961	Bar
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bar

Batch: B 25849

4.0	D3446041	Harness Assembly
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 15.0000 Each(s)

Harness Assembly

Batch: B 25598 (9mx) ✓ B 26777 (6mx) ✓

5.0	D32681	Placard
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Placard

Batch: B 26338 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 2:33:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 5-MAN SHOULDER HARNESS KIT

Job Number: 27935

Part Number: D412702033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS24694S152	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch: M100680 ✓

7.0	MS24694S154	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

Batch: M100680 ✓

M.E. 06/07/20

(3)

8.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

P 6/7/20 (3)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-033

Location: NEVA

P 6/7/20 (3)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.21

Job Completion



U 8.07.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9312	REV. B SHEET 1 OF 1
DATE 06.03.24		TITLE UH-1 HARNESS INSTALLATIONS	SCALE NTS
A	05.09.29	NEW ISSUE	
B	06.03.24	REFORMAT, ADD -S154 SCREWS	

DART SERVICE INSTRUCTION

REFERENCE: INSTALLATION INSTRUCTIONS IIN-D412-702 REV. B or C

The following kit is available to provide 4-point shoulder harnesses for passengers on UH-1 aircraft:

The Dart **D412-702-033** 5-Man Shoulder Harness Kit provides 4-point harnesses for the 5 fwd-facing seating positions in the UH-1 aircraft cabin. The harnesses for this kit are approved under TSO-C114. This kit should be installed as per the D412-702-023 kit in installation instructions IIN-D412-702 except that the existing tubes (p/n 205-070-709-1) for the fwd-facing seats should be used to secure the shoulder harnesses instead of the D3197-041 bars (and associated fittings, ref.).

When installing the D3196-1 Bar, it is acceptable to substitute the MS24694-S152 screws for the longer MS24694-S154 screws (or longer MS24694-Sxxx screws as required) to ensure the bar is properly secured.

For each of the two outermost passenger positions, it is acceptable to install all 4 shoulder straps onto the existing seat tubes (p/n 205-070-709-1), instead of installing one on the D3196-1 Bar as per IIN-D412-702. Thus, for cases where the centermost seating position has been removed (or not used), installation of the D3196-1 Bar is not required.

The parts list for the kits are as follows:

QTY -033	Part Number	Description
X	D412-702-033	Dart 5-Man Shoulder Harness Kit, 4-point, for UH-1 aircraft
1	D3196-1	Bar
5	D3446-041	Harness Assembly, 4 point
2	D3268-1	Placard
2	MS24694-S152	Screw
2	MS24694-S154	Screw (use either -S152, -S154, or longer screws as req'd)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27935

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Date: Friday, 15/12/2006 9:48:32 AM
 User: Linda Lacelle

Process Sheet

D412-702-033B27935

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 29986
 Estimate Number : 10804
 P.O. Number : N/A
 This Issue : 15/12/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 00015
 Written By :
 Checked & Approved By :
 Comment :

Drawing Name : D3196-1
 Part Number : D31961
 Drawing Number : REWORK-ECN871
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 22/12/2006

Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 B25849 8X B25108 1X B25100 1X frank's (10X)
 D412-702-021 B26883 3X B25853 1X (4)
 D412-702-023 B26074 3X B27225 1X B25765 2X (5)
 D412-702-033 327 935 1X (1)
 (AND FROM WIP)
 D412-702-011
 06/12/18

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0 D31961 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
 Bar

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1
 PER ECN 871

06/12/18

16

Date: Thursday, 12/10/2006 2:56:32 PM
 User: Linda Lacelle

Process Sheet

D412-702-033 B27935

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D412-702

Job Number : 28952

Estimate Number : 10804

P.O. Number : N/A

Part Number : Z_CUSTOM

This Issue : 12/10/2006

S.O. No. : N/A

Drawing Number : UPDATE PAPERWORK

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A

Type : OVERHEAD

Drawing Revision : N/A

Previous Run : 00015

Material : N/A

Written By :

Due Date : 19/10/2006

Qty: 1 Um: Each

Checked & Approved By :

Comment :

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 REMOVE KITS FROM STOCK

D412-702-011

D412-702-013

D412-702-021 B268830 B25853 1X

D412-702-023 B2576520 B26074 3X

D412-702-033 1X B27935

ADD NEW PAPERWORK DSI 9354 REV.A

P. 06/10/20

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 RETURN TO STK

P. 06/10/20

3.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P. 06/10/20

Job Completion



U Do. W. 26